

Split

Work Order ID 102293-1

May-27-13 2:25:11 PM

102293

Page 1

Item ID: D3197-041

Revision ID:

Item Name: Bar Assembly

Start Date: 5/27/13

Start Qty: 6.00

Required Date: 5/31/13

Req'd Qty: 6.00

Reference:

Accept

N9000040100

Setup Start

NS1

Stop

NS2

Cust Item ID:

Customer:

6 - 4 - 4
6

Approvals:

Process Plan:

MLJ

Date: 13-05-27

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3197

Rev B

100

0.00

100

BAND SAW

Bandsaw

Memo

0.00

Jeaspa Bandsaw

Cut blanks: 29.125" long

SA 13-5-29

G 4

110

0.00

110

HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

1-Face ends to length per dwg D31972-Machine D3197-1 as per Folio FA340 and Dwg D31973-Deburr

85 13 05 30 (x)

120

0.00

120

QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

13 05 30 (x4)

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Item ID: D3197-041

Accept

N900040100

Setup Start *NS1*

Revision ID:

Item Name: Bar Assembly

Stop *NS2*

Start Date: 5/27/13 Start Qty: 6.00

6

Required Date: 5/31/13 Req'd Qty: 6.00

6

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

130

Lathe Conv

Conventional Lathe

CONVENTIONAL LATHE

Memo

Chamfer as per Dwg D3197

0.00

0.00

13-5-29

4

140

140

QC

Quality Control

QC8- Inspect parts - second check

Memo

0.00

0.00

13/05/31

4

150

150

HandFinish

Hand Finishing

Chemical Conversion Coat per QSI005 4.1

Memo

0.00

0.00

4 13.6.3

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Item ID: D3197-041

Accept

N9000040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Bar Assembly

Start Date: 5/27/13 Start Qty: 6.00

6

Cust Item ID:

Required Date: 5/31/13 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan Code Accept Qty Reject Qty Reject Number Insp. Stamp

160

Grey Sandtex(Ref:4.3.5.6) per QS1005 4.3

0.00

160

Powdercoat

Memo

0.00

Powder Coating

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

170

QC3- Inspect Part Finish

0.00

170

QC

Memo

0.00

Quality Control

180

Small Fab

0.00

180

Small Fab

Memo

0.00

Small Fab

Assemble D3197-041 as per Dwg D3197

4X4 m/f 13/06/03

4 φ B-6-B

2 φ

FF13-06-03

QC 5

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Item ID: D3197-041

Revision ID:

Item Name: Bar Assembly

Start Date: 5/27/13 Start Qty: 6.00

Required Date: 5/31/13 Req'd Qty: 6.00

Reference:

Accept

N900040100

Setup Start

NS1

Stop

NS2

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

Stop

NR2

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

190

QC5- Inspect part completeness to step on W/O

0.00

190

QC

Memo

0.00

Quality Control

SHIP
1363

28

200

Identify as per dwg & Stock Location: _____

0.00

200

Packaging

Memo

0.00

Packaging

SHIP

13-06-03 (2)

210

QC21- Final Inspection - Work Order Release

0.00

210

QC

Memo

0.00

Quality Control

MLJ 13-06-03

MLJ 13-06-03

13-06-04

Picklist Print

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Work Order ID: 102293

Parent Item: D3197-041

Parent Item Name: Bar Assembly

Start Date: 5/27/13

Required Date: 5/31/13

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP Rev: A New Issue 05-11-08 JLM
IPP Rev: B As per Rev B 06-03-10 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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MS27039-1-24
Screw

Purchased No

100 Each 50.0000

2 12

FF 13-06-03

Location

GA

Loc Qty

50

Loc Code

AN960JD10

NAS1149D0363J

Purchased

No

180 Each 0.0000

6 36

FF 13-06-03

Washer

D2690-5

Lanyard Assembly

Manufactured

No

180 Each 9.0000

2 12

FF 13-06-03

Location

ST014

Loc Qty

9

Loc Code

D3242-1

Tag

Manufactured

No

180 Each 12.0000

2 12

FF 13-06-03

Location

GA

Loc Qty

12

Loc Code

D3489-3-200

PIP PIN

Manufactured

No

180 Each 17.0000

2 12

FF 13-06-03

Location

GA

Loc Qty

17

Loc Code

100724

12

96109

5

Picklist Print

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Work Order ID: 102293
 Parent Item: D3197-041
 Parent Item Name: Bar Assembly

Start Date: 5/27/13

Required Date: 5/31/13

Start Qty: 6.00

Required Qty: 6.00

M7075T73R1.000
 7075-T73 Rd Bar 1.00

Purchased No

180 F 65.3200 2.42 18.15

Location

Loc Qty

Loc Code

MAT012

65.32

120503

11.05

122386

6.27

125586

48

MS21042L3

Purchased No

Nut

180 Each 3,231.0000

2 12

Location

Loc Qty

Loc Code

FP001

3

122141

3

GA

18

122452

18

ST314

268

117885

32

119017

55

119075

138

123265

43

ST506

2942

123900

954

124291

1988

SA-13-5-2

14.625 Lt

FF13-06-03

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Shop Packet Print

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FIRST ARTICLE INSPECTION CHECKLIST

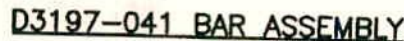
☒ First Article ☐ Prototype[illegible]

Measured by: <i>RT</i>	Audited by: <i>GM</i>	Prototype Approval:	N/A
Date: <i>13 05 30</i>	Date: <i>13/05/31</i>	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.04.20	New Issue (P/O D3197-041)	KJ/JLM	
B	07.03.09	Dwg revision update	KJ/JLM	

~~206~~ 206

ART



- 1) MATERIAL: 7075-T73 ROUND BAR (QQ-A-200/11 or QQ-A-225/9) ϕ 1.000 O.D.
(REF DART SPEC. M7075T73R1.000)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) FOR TOOLING, IT IS ACCEPTABLE TO HAVE A 0.06 DEEP x 60° CENTER MARK AT EITHER
END OF THE BAR

DESIGN		DRAWING NO.		REV. B
CP	APPROVED	D3197	SHEET 1 OF 1	
CP	DATE	TITLE	SCALE	
	06.01.10	BAR	1:1	
A	03.07.01	NEW ISSUE		
B	06.01.10	CHG PIP PIN; ADD D3242-1 TAG		

102293 MGS
13-05-22